

suited to its purpose, because the bearing point on the work is closer to the bolt body.

Screw Tightening Devices.  
— In a box jig, or a jig where the work is entirely, or almost entirely, surrounded by the jig, the work is easily held in place by set-screws which are used when-

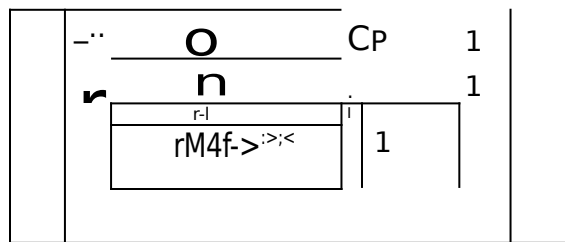


Fig. 18. Simple Clamping Method

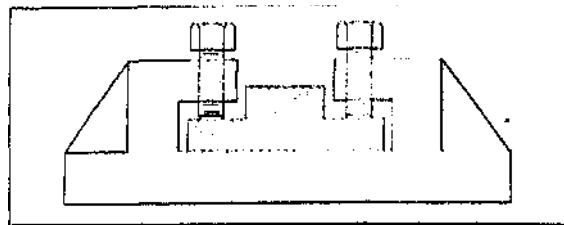


Fig. 19. Clamping by  
Set-screws in Open-end  
Jig

Fig. 20. Clamps that  
hold the Work Firmly In  
place

ever great clamping pressure is required, the square head allowing the use of the wrench. Sometimes screws of this kind may be tightened enough for the purpose by hand if a pin is put through the head, of the

screw, as shown in Figs, 22 and 23.

This means is used not only when great pressure is not necessary, but also when the work is liable to spring if the screws are